

for blue

Work Order ID 62634



Page 1

Tuesday, October 05, 2010 1:02:01 PM

Item ID: D206-667-203TRN

Accept



Setup Start



Revision ID:

Item Name: Crosstube Turning Detail

Stop



Start Date: 10/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *fl*

Date: 10-10-05 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|--------------|--------------|--|--|--|--|--|--|--|--|
| D206-667-243 | Rev C | | | | | | | | |

100



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

110



QC1- Inspect dimensions to dimension sheet

QC

Quality Control

120



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

0.00

0.00

0.00

0.00

0.00

*mk/H.A 10/10/12**1 0**1 0**1 0*

Memo

Memo

Memo

Memo

1-Turn second side as per Folio FA089 □2-File down transition lines smooth.

□

3-Remove sand and plugs □4-Scrib part# and batch #

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00

N.A 10/10/12

1 φ



QC

Memo

0.00

140

QC8- Inspect parts - second check

0.00

S 10/10/13

+0



QC

Memo

0.00

150

Crosstubes Chemical Conversion

0.00

SAD
10-10-13

①



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Tuesday, October 05, 2010 1:02:01 PM



Page 3

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Start



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Customer:

Reference:

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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

= M.P 10/10/14

(R)

170



Packaging

Packaging

0.00

Packaging

Memo

0.00

Identify and Stock in kanban rack

□ Location: 4/G

Q 10-10-14 X

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/14 H

MF 10-10-14

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 05, 2010 1:02:05 PM

Page 1

Work Order ID: 62634



Parent Item: D206-667-203TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 10/5/2010

Required Date: 10/19/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified by: DD
IPP Rev C 09.01.06 ECN 08-562 EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6004-115 | | Manufactured | No | | | 100 | Each | 54.0000 | 1 | 1 | | | |

Crosstube Material

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 54 | |
| 34685 | 17 | |
| 34774 | 2 | |
| 38336 | 35 | |

awh 10/10/08

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

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|-------------------------------------|--------------|--------------|
| DART AEROSPACE LTD | Work Order: | 62634 |
| Description: Crosstube Assembly | Part Number: | D206-667-243 |
| Inspection Dwg: D206-667-243 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|-------------|------------------|-------------|--------|----------------------|----------|
| SIDE A | 2.490 | +0.005/-0.000 | 2.494 | ✓ | Vern | GA-01 |
| | 2.018 | +0.005/-0.000 | 2.023 | ✓ | " | " |
| | 2.079 | +0.005/-0.000 | 2.084 | ✓ | " | " |
| | 2.145 | +0.005/-0.000 | 2.150 | ✓ | " | " |
| | 2.209 | +0.005/-0.000 | 2.214 | ✓ | " | " |
| | 2.287 | +0.005/-0.000 | 2.288 | ✓ | " | " |
| | 2.363 | +0.005/-0.000 | 2.364 | ✓ | " | " |
| | 2.433 | +0.005/-0.000 | 2.436 | ✓ | " | " |
| | 0.200 | +/-0.010 | 0.205 | ✓ | Vern | GA-01 |
| | 0.500 x 30° | +/-0.010 | 0.500 x 30° | ✓ | " | " |
| | R0.063 | +/-0.010 | R0.063 | ✓ | Rad Gage | ref. |
| | R0.500 | +/-0.010 | R0.500 | ✓ | " | " |
| | 4.438 | +/-0.030 | 4.443 | ✓ | Vern | GA-01 |
| | 104.91 | +/-0.020 | 104.920 | ✓ | TAPE | GA-12 |
| | 2.490 | +0.005/-0.000 | 2.495 | ✓ | Vern | GA-01 |
| SIDE B | 2.018 | +0.005/-0.000 | 2.023 | " | " | " |
| | 2.079 | +0.005/-0.000 | 2.084 | ✓ | " | " |
| | 2.145 | +0.005/-0.000 | 2.150 | ✓ | " | " |
| | 2.209 | +0.005/-0.000 | 2.214 | ✓ | " | " |
| | 2.287 | +0.005/-0.000 | 2.290 | ✓ | " | " |
| | 2.363 | +0.005/-0.000 | 2.364 | ✓ | " | " |
| | 2.433 | +0.005/-0.000 | 2.437 | ✓ | " | " |
| | 0.200 | +/-0.010 | | | Vern | GA-01 |
| | 0.500 x 30° | +/-0.010 | 0.500 x 30° | | " | " |
| | R0.063 | +/-0.010 | R0.063 | ✓ | Rad Gage | ref |
| | R0.500 | +/-0.010 | R0.500 | ✓ | " | " |
| | 4.438 | +/-0.030 | 4.448 | ✓ | Vern | GA-01 |

| | | | | | |
|--------------|----------|-------------|----------|-----------------------|-----|
| Measured by: | J.A | Audited by: | 8 | Preliminary Approval: | N/A |
| Date: | 10/10/12 | Date: | 10/10/12 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 06.09.01 | New Issue (P/O D206-667-203) | KJ/JLM | |
| B | 10.08.25 | Dwg Rev updated | KJ | |

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

| Item | Qty | Part Number | Description |
|------|-----|----------------|--|
| 1 | X | D206-667-243 | CROSSTUBE ASSEMBLY (206L HIGH AFT) |
| 2 | 1 | D6004-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2892-1 | SUPPORT |
| 6 | 4 | D3595-063-450 | RUBBER CUSHION |
| 7 | 4 | MS21920-22 | CLAMP |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBC-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91 ± 0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP
RFI
ENG
UNCONT
SUBJECT
WITH
WORK
NO. *Call 634*
28/10/05

RELEASED

| | | | | |
|------------|--|--|---|----------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN AB-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BH7/A SKUDTUBES | | PH | 05.07.26 |
| A | NEW ISSUE | | CP | 00.11.17 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | <i>P</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | RF | | | |
| CHECKED | <i>IP</i> | DRAWING NO. D206-667-243 REV. C | | |
| MFG. APPR. | <i>E</i> | SHEET 1 OF 4 | | |
| APPROVED | <i>TJ</i> | TITLE CROSSTUBE ASSY (206L HIGH AFT) NTS | | |
| DE APPR. | <i>W</i> | SCALE | | |
| DATE | 08.11.06 | | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS REPRODUCED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

8 7 6 5 4 3 2 1

3 2 1

1

D

C

B

A

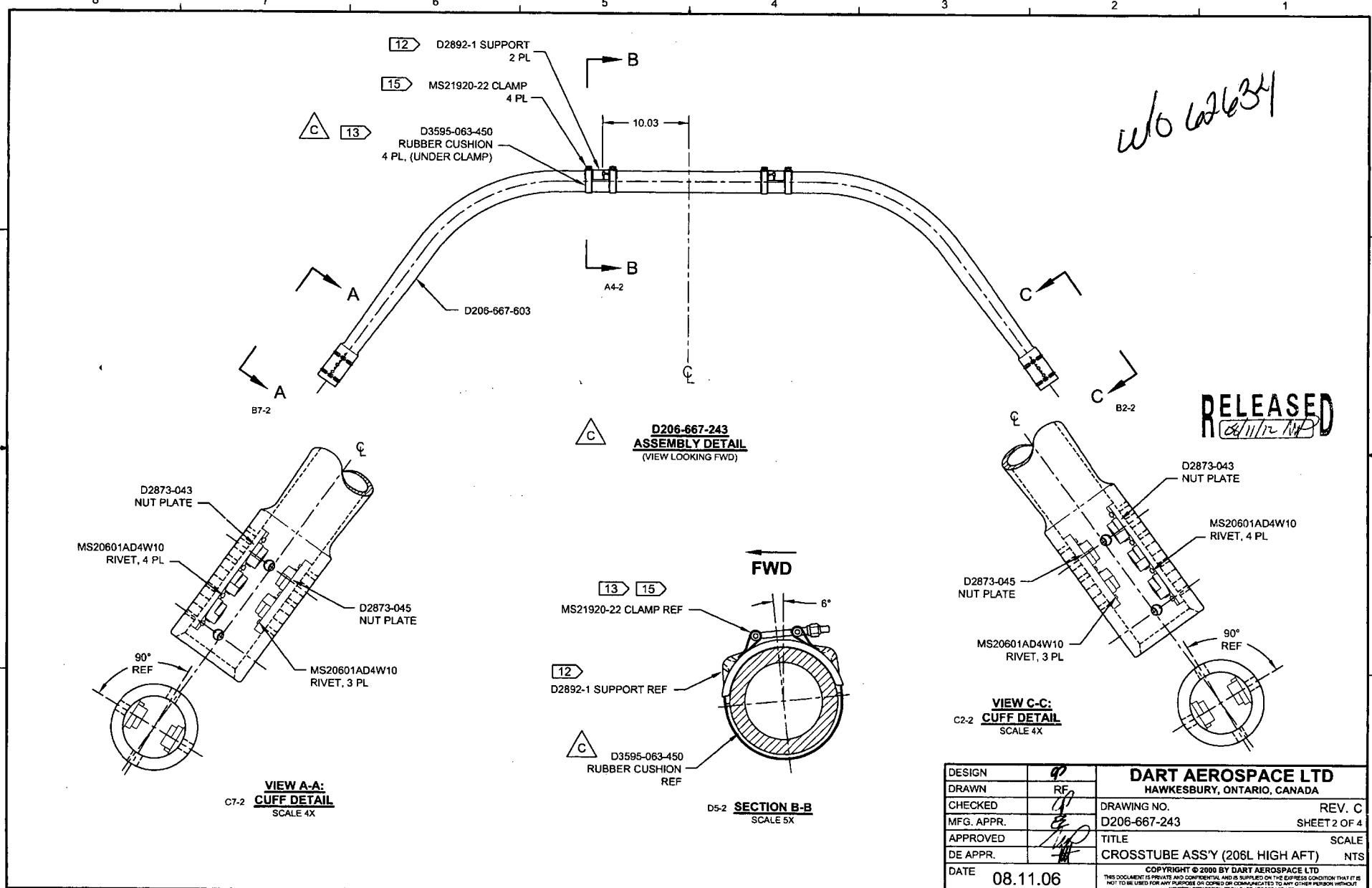
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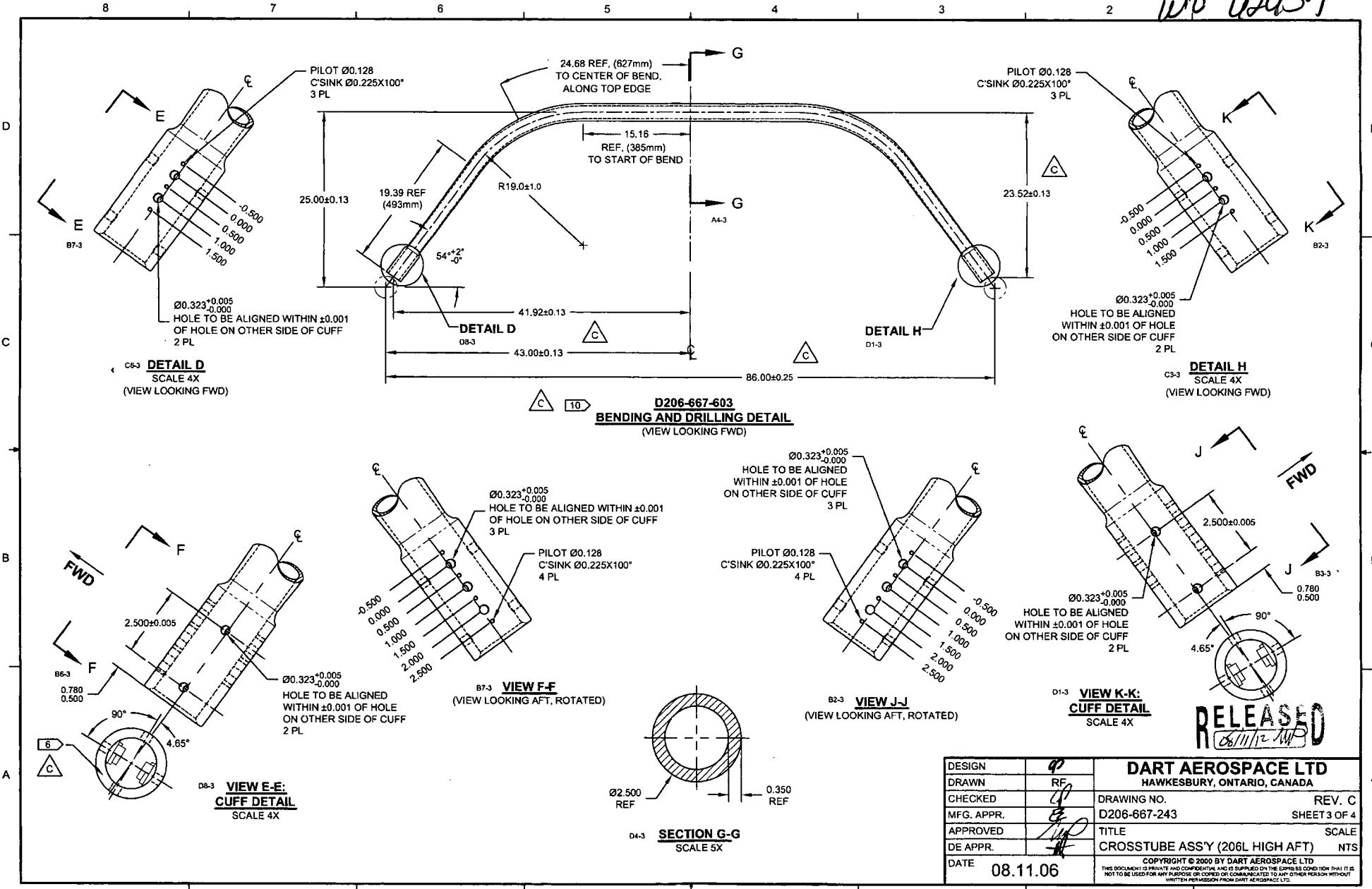
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Wb 42634



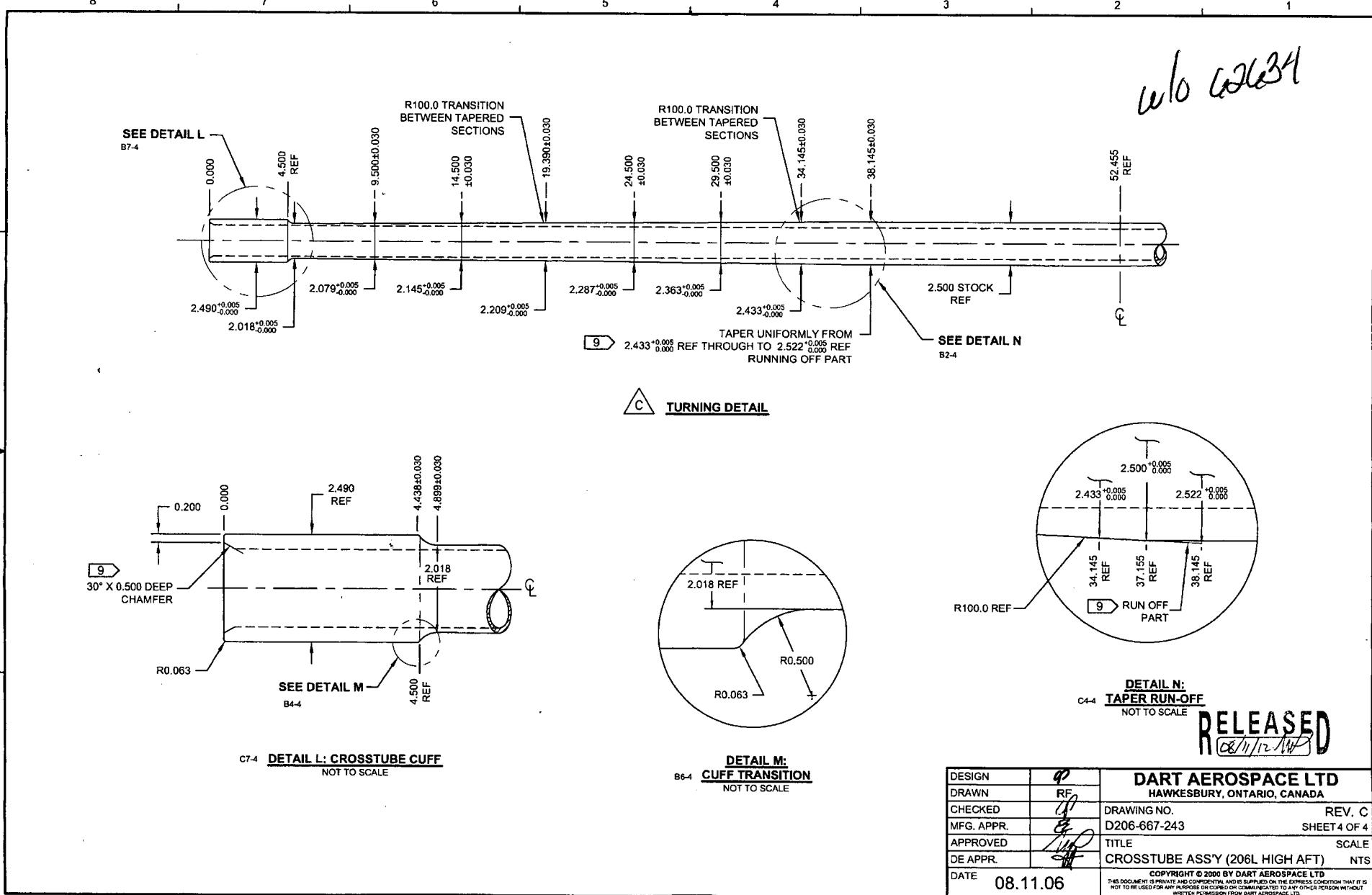
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|--|----|---|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | DRAWING NO. D206-667-243 |
| CHECKED | RF | REV. C |
| MFG. APPR. | RF | SHEET 4 OF 4 |
| APPROVED | RF | TITLE CROSSTUBE ASSY (206L HIGH AFT) NTS |
| DE APPR. | RF | DATE 08.11.06 |
| COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | |

RELEASED
08/11/2011

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